

Split

Sun 8 DEC 2nd

Work Order ID 153330-2

153330

Page 1

Wednesday, November 16, 2016 11:09:21 A

Item ID: 647.7601 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Lower Deflector Assembly Stop *NS2*

Start Date: 11/21/2016 Start Qty: ~~7.00~~ *7* Cust Item ID:

Required Date: 11/24/2016 Req'd Qty: 7.00 *7* Customer:

Reference:

Approvals: Process Plan: VS ^{DAS} 21 ₉₋₈₉ Date: 11/21/16 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.7600	NC

110	Pick Kit	0.00
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110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

DEC 05 2016

120

120

Small Fab

Memo

0.16

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 5.

A/R RTV LOCTITE 598: 135385
exp. date: 04/18

6x _____ 16/2/19

DAS
36
9-89

130

130

QC

Memo

0.02

Quality Control

QCS- Inspect part completeness to step on W/O

6 16/2/19 DAS
9
9-89

Work Order ID 153330

Wednesday, November 16, 2016 11:09:21 A

153330

Page 2

Item ID: 647.7601

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Lower Deflector Assembly

Stop ***NS2***

Start Date: 11/21/2016 Start Qty: 7.00

7

Cust Item ID:

Required Date: 11/24/2016 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CCK065</u>	0.00				<u>6</u>	<u>9107-6-330</u>	<u>DEC 19 2016</u>	<u>DAS</u> <u>6</u> <u>9-89</u>
140	Memo	0.01							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150	Memo	0.12				<u>DAS</u> <u>21</u> <u>9-89</u>		<u>DEC 19 2016</u>	
QC									
Quality Control									


DEC 19 2016

Picklist Print

Wednesday, November 16, 2016 11:09:27 AM

Page 1

Work Order ID: 153330

153330

Parent Item: 647.7601

647 7601

Parent Item Name: Lower Deflector Assembly

Start Date: 11/21/2016

Required Date: 11/24/2016

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP REV:A NEW ISSUE 15-08-04 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7611 ✓ *647 7611* ✓ Lower Deflector		Manufactured	No				Each	0.0000	**	7 (3335)		DEC 15 2016	DAS 6 9-89
647.7612 ✓ *647 7612* Breakaway Tip		Manufactured	No				Each	5.0000	**	7 (3336x2)		DEC 05 2016	DAS 6 9-89
Location Loc Qty Loc Code													
CCK113 5													
138616 5													
MS20470AD6-14 *MS20470AD6-14* Rivet		Purchased	No				Each	284.0000	**	14 5		DEC 15 2016	DAS 6 9-89
Location Loc Qty Loc Code													
ST308 284													
m133284 284													

M520470AD6-12

M127304

(14x)

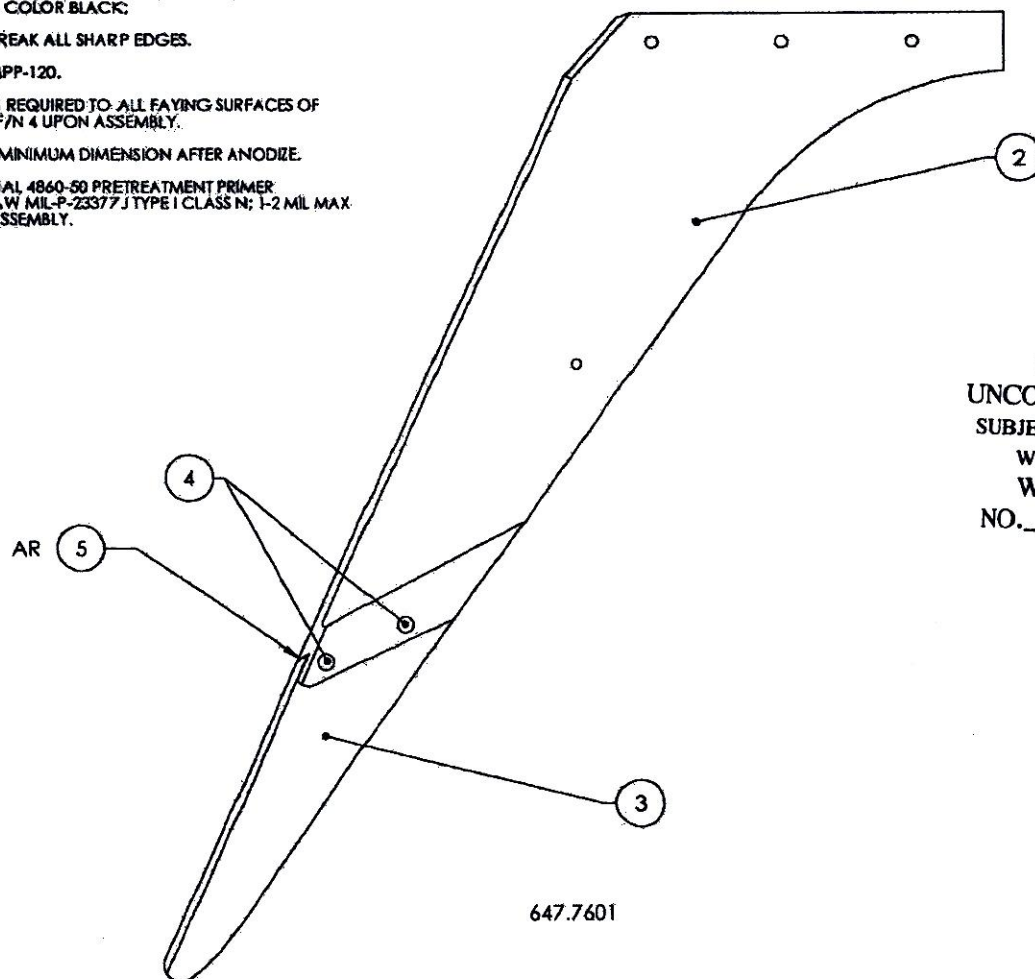
16/12/15

DAS
36
9-89

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NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE 1AW MIL-A-8625 TYPE II, CLASS 2, COLOR BLACK;
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY 1AW MPP-120.
- 5 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2, F/N 3 & F/N 4 UPON ASSEMBLY.
- 6 MAXIMUM OR MINIMUM DIMENSION AFTER ANODIZE.
- 7 FINISH: CARDINAL 4860-50 PRETREATMENT PRIMER PRIME 1AW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX. AFTER ASSEMBLY.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY 16/11/16
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153330

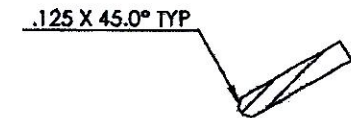
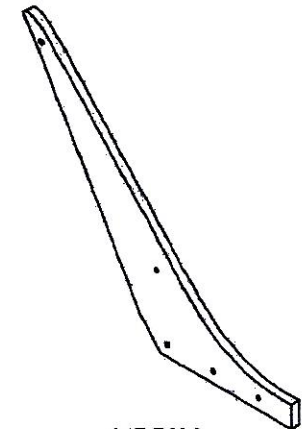
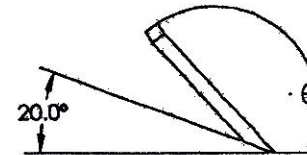
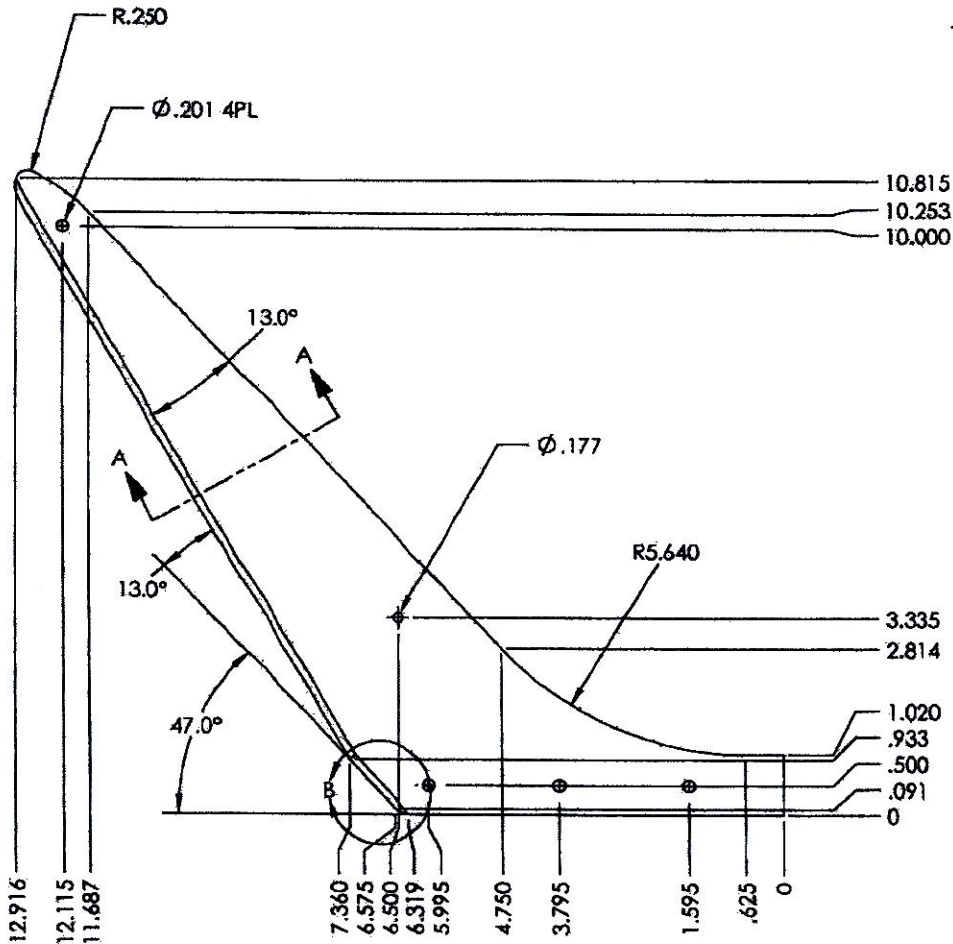
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PRODUCTION RELEASED FOR		N/C
2	REWORK RELEASE	10/22/09	P. BRAY

A/R	QTY	PART #	DESCRIPTION	MATL	SPEC.
2	4	601.3122	RIVET	MS20470ADN-14	
1	3	647.7612	BREAKAWAY TIP	△	△
1	2	647.7611	LOWER DEFLECTOR	△	△
	1	647.7610	UPPER DEFLECTOR	△	△
		647.7601	LOWER DEFLECTOR ASSY		△
7601	FIND #	PART #	DESCRIPTION	MATL	SPEC.
	QTY				
	NEXT ASSY (S)				
	647.7400				
	647.7500				

ORIGINAL DATE 10/22/09 DRAWN BY A. OLSON CHECKED BY P. BRAY APPROVAL DATE 10/22/09 CONTRACTING	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300 DEFLECTORS SHEET 1 OF 4
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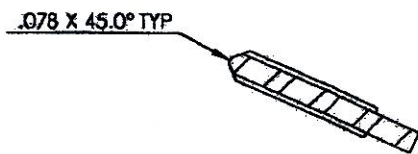
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE PROJECT NO. DRAWING NO. A. OSMAN P. BRAY DRAWING APPROVAL CHECKED CORRECTED	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 DEFLECTORS ALL DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED TOLERANCES ARE: FRACTIONS DECIMALS PERCENT 1/16 0.0625 15% 1/32 0.0312 15% 1/64 0.0156 15% 3/32 0.0937 15% 1/8 0.125 15% 3/16 0.1875 15% 1/4 0.25 15% 5/16 0.3125 15% 3/8 0.375 15% 7/16 0.4375 15% 1/2 0.5 15% 5/8 0.625 15% 3/4 0.75 15% 7/8 0.875 15% 1 1.0 15% 1 1/8 1.125 15% 1 1/4 1.25 15% 1 3/8 1.375 15% 1 1/2 1.5 15% 1 5/8 1.625 15% 1 3/4 1.75 15% 1 7/8 1.875 15% 2 2.0 15% 2 1/8 2.125 15% 2 1/4 2.25 15% 2 3/8 2.375 15% 2 1/2 2.5 15% 2 5/8 2.625 15% 2 3/4 2.75 15% 2 7/8 2.875 15% 3 3.0 15% 3 1/8 3.125 15% 3 1/4 3.25 15% 3 3/8 3.375 15% 3 1/2 3.5 15% 3 5/8 3.625 15% 3 3/4 3.75 15% 3 7/8 3.875 15% 4 4.0 15% 4 1/8 4.125 15% 4 1/4 4.25 15% 4 3/8 4.375 15% 4 1/2 4.5 15% 4 5/8 4.625 15% 4 3/4 4.75 15% 4 7/8 4.875 15% 5 5.0 15% 5 1/8 5.125 15% 5 1/4 5.25 15% 5 3/8 5.375 15% 5 1/2 5.5 15% 5 5/8 5.625 15% 5 3/4 5.75 15% 5 7/8 5.875 15% 6 6.0 15% 6 1/8 6.125 15% 6 1/4 6.25 15% 6 3/8 6.375 15% 6 1/2 6.5 15% 6 5/8 6.625 15% 6 3/4 6.75 15% 6 7/8 6.875 15% 7 7.0 15% 7 1/8 7.125 15% 7 1/4 7.25 15% 7 3/8 7.375 15% 7 1/2 7.5 15% 7 5/8 7.625 15% 7 3/4 7.75 15% 7 7/8 7.875 15% 8 8.0 15% 8 1/8 8.125 15% 8 1/4 8.25 15% 8 3/8 8.375 15% 8 1/2 8.5 15% 8 5/8 8.625 15% 8 3/4 8.75 15% 8 7/8 8.875 15% 9 9.0 15% 9 1/8 9.125 15% 9 1/4 9.25 15% 9 3/8 9.375 15% 9 1/2 9.5 15% 9 5/8 9.625 15% 9 3/4 9.75 15% 9 7/8 9.875 15% 10 10.0 15%	SHEET 2 OF 4
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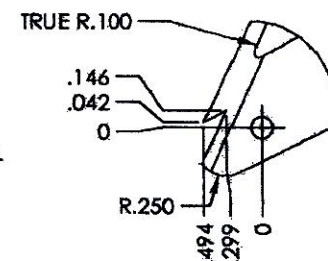
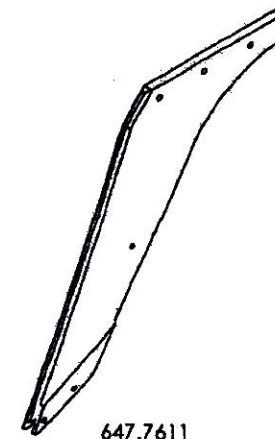
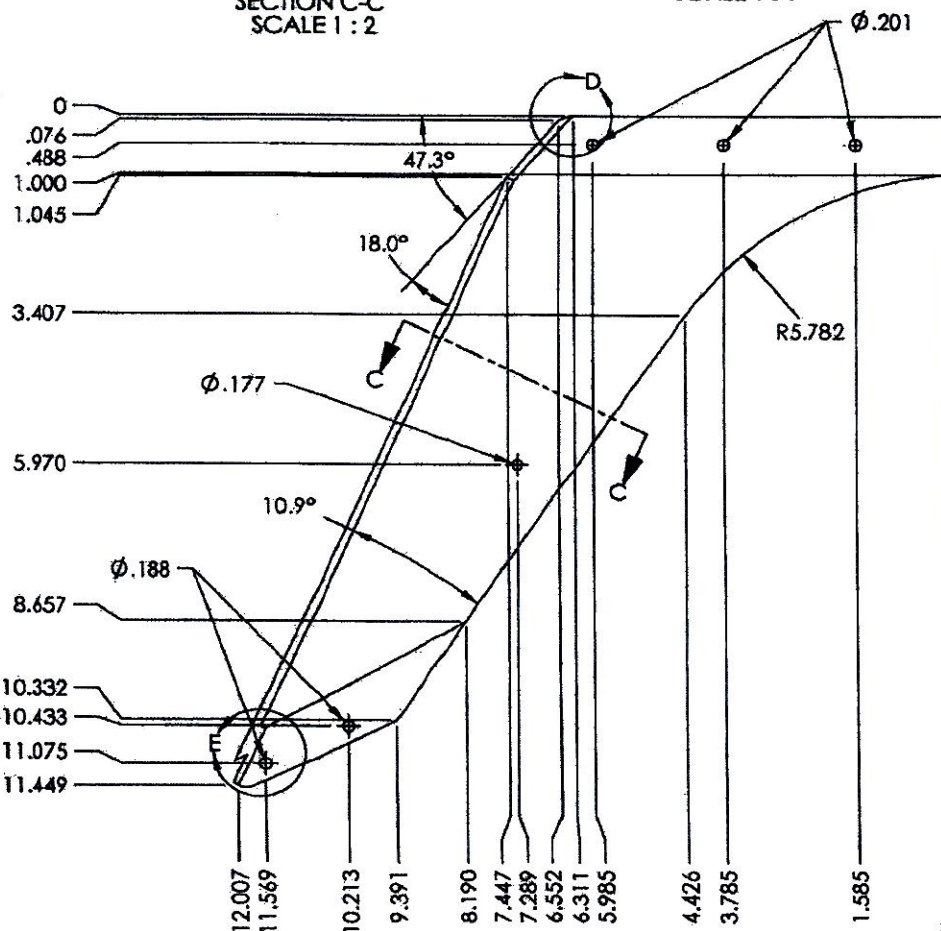
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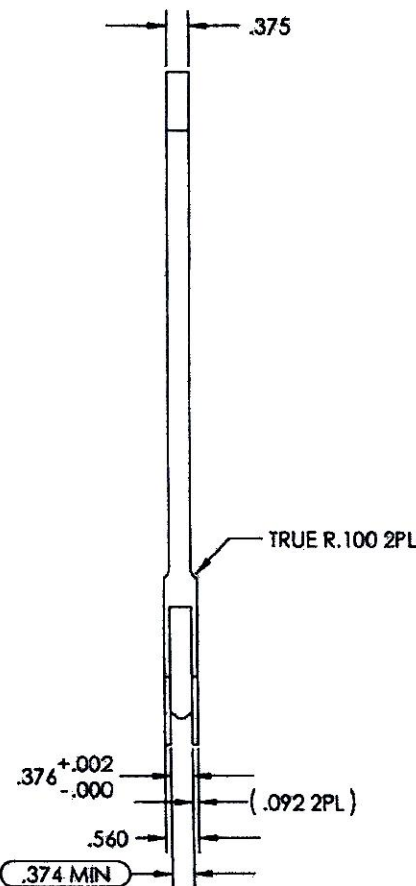
SECTION C-C
SCALE 1:2



DETAIL D
SCALE 1:1



DETAIL E
SCALE 1:1



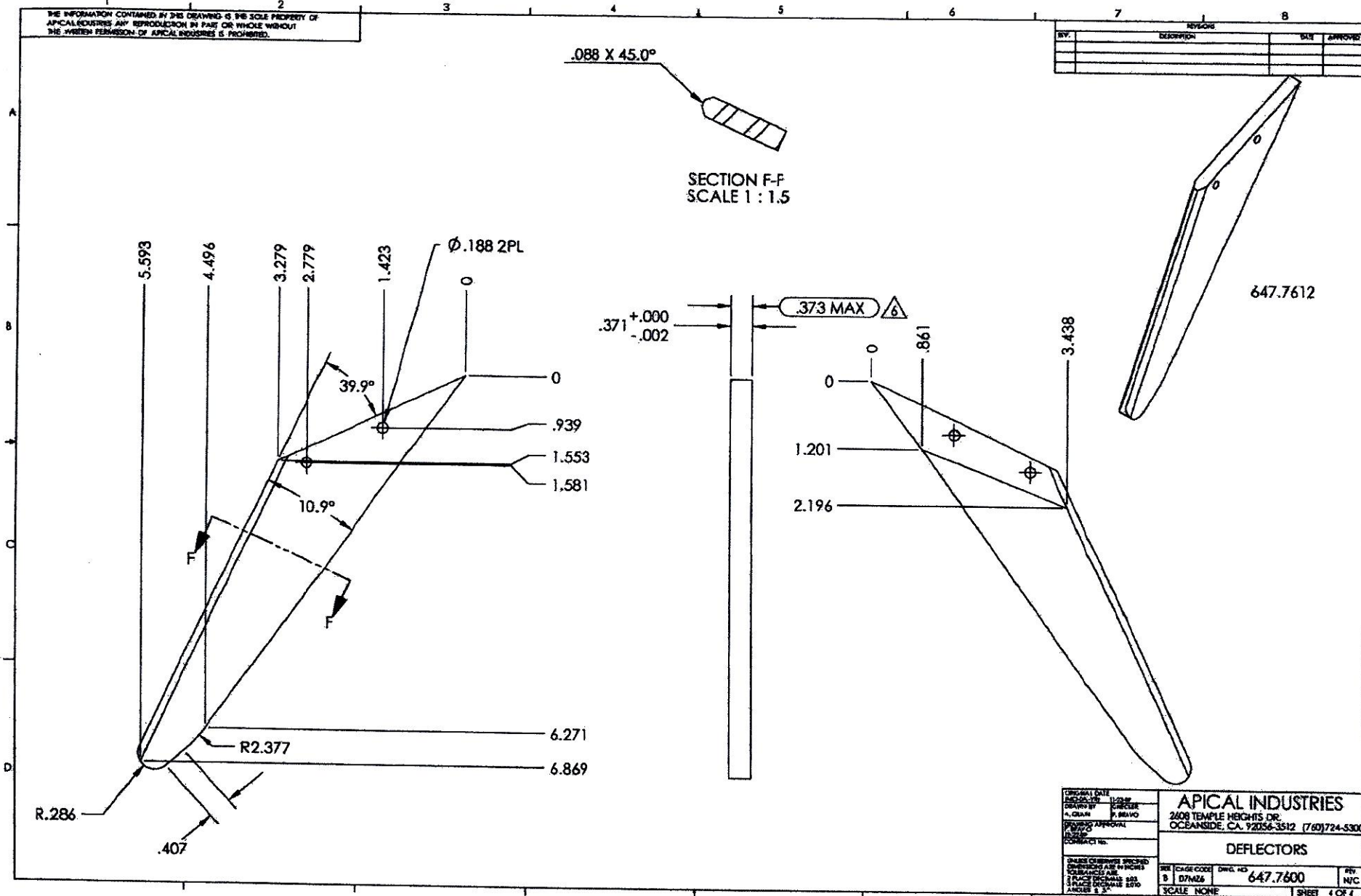
ORIGINAL DATE 11-22-88 DESIGNED BY A. EDWARDS DRAWN BY P. BRADY CHECKED BY M. J. JONES CONTROL NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92054-3512 (760)724-5300 DEFLECTORS 647.7600 SCALE NONE	REV. 8 07/02/88 N/C 1 SHEET 3 OF 4
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SECTION F-F
SCALE 1:1.5

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE APPROVAL DESIGNED BY A. OLAN DRAWING APPROVAL DATE CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. PLACE DECIMALS 200 2. PLACE DECIMALS 100 3. PLACE DECIMALS 500 4. PLACE DECIMALS 250		DEFLECTORS REV. 647.7600 SCALE NONE SHEET 4 OF 7